

Date: Tuesday, 27/05/2008 3:01:55 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FITTING
<b>Job Number</b> :	39525		
<b>Estimate Number</b> :	10416		
<b>P.O. Number</b> :		<b>Part Number</b> :	D31981
<b>This Issue</b> :	27/05/2008	<b>Drawing Number</b> :	D3198 REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	/ /	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	39320	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	02/06/2008
<b>Checked &amp; Approved By</b> :	JLD 08.5.27	<b>Qty:</b>	30
<b>Comment</b> :	Est: A 03.11.11 New Issue KJ/RF	<b>Um:</b>	Each
	Est Rev: B Now on Waterjet 07-01-09 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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**Comment:** Qty.: 0.1103 sf(s)/Unit Total: 3.3075 sf(s)

304/316 .125 Sheet

Batch: 108156 HB 8-5-28

MAT NOT PULLED

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3198

Dwg Rev: A

Prog Rev: A

HB 8-5-28

(39)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 8-5-28

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/05/28 (39)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D3198

→ B 08/05/28

(39)

HB 08/05/29

(39)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 27/05/2008 3:01:55 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 39525

Part Number: D31981

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

S 08/05/29 (39)

7.0

POWDER COATING

POWDER COATING



m/05642

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

18:00

OVEN TEMPERATURE:

320°

FINISH TIME:

10:30

FL 08/05/29 (39)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(39)

Comment: INSPECT POWDER COAT

hl 08-05-29

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57243

08/06/30 (39)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 08.06.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Ø. 266  
11/08/05/28

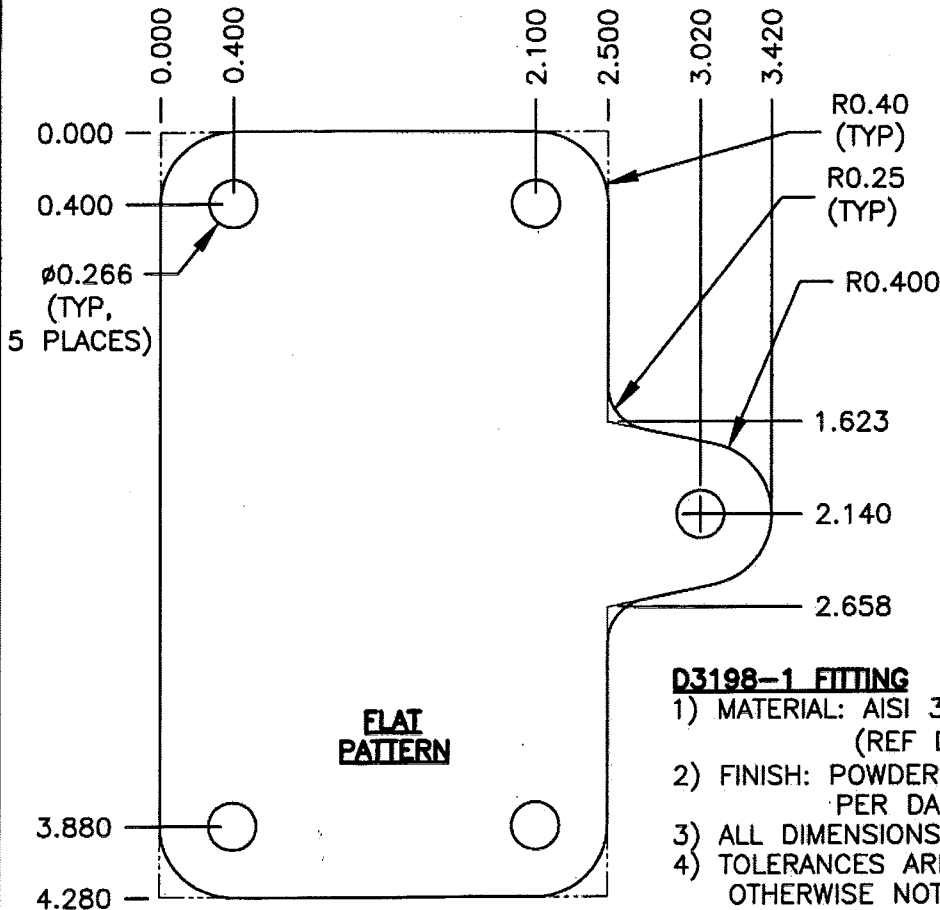
<input checked="" type="checkbox"/> First Article	<input type="checkbox"/> Prototype
<p>1. <b>Introduction</b></p> <p>2. <b>Materials and Methods</b></p> <p>3. <b>Results</b></p> <p>4. <b>Discussion</b></p> <p>5. <b>Conclusion</b></p>	<p>1. <b>Introduction</b></p> <p>2. <b>Materials and Methods</b></p> <p>3. <b>Results</b></p> <p>4. <b>Discussion</b></p> <p>5. <b>Conclusion</b></p>

Measured by:	B	Audited by:		Prototype Approval:	N/A
Date:	8-5-28	Date:	08/05/28	Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3198	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	

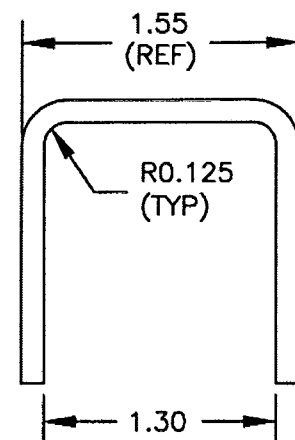
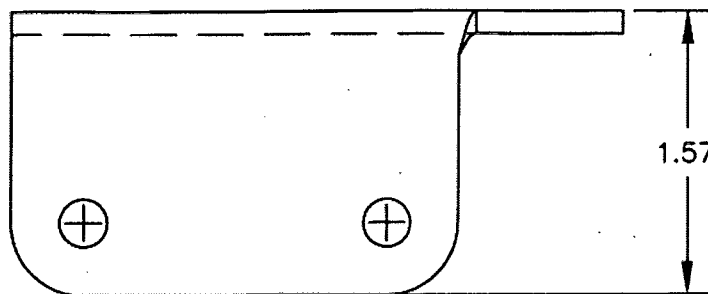


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39525

**D3198-1 FITTING**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK  
(REF DART SPEC. M304S11GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED  
03.10.10 *#*

**BEND  
DETAIL****Copyright © 2003 by DART AEROSPACE LTD**

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